

5/30

DART AEROSPACE LTD.	Work Order:	23801
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	12
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	<i>[Signature]</i>	05.07.14	12
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B21818</u>	J.L	05.07.18	12
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B23249</u>	J.L	05.07.18	12
4	MV	Fixturing W/O No. <u>1</u> Fixturing Inspection last completed <u>1</u> by <u>1</u>	<u>1</u>	<u>1</u>	<u>1</u>
5	MV	Program Batch No. <u>23801</u> Double check by: <u>EC</u>	<u>9M</u>	05/07/19	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	<u>9M</u>	05/07/25	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	<u>9M</u>	05/07/25	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	<u>9M</u>	05/07/25	12
9	MV	Machine keyway as per dwg D2571 & D2572	<u>9M</u>	05/07/25	12
10	MV	Deburr and remove all machining marks	<u>9M</u>	05/07/25	12
11	MV	Tumble for 20 minutes to remove sharp edges # <u>04.00.21</u>	<u>9M</u>	05/07/25	12
12	QC1	Inspect all dimensions to dimension sheets	<u>9M</u>	05/07/25	12
13	QC7	Second inspection	<u>EC</u>	05.07.25	12
14	FP	Acid etch and alodine as per QSI 005 4.1	<u>PMC</u>	05-7-27	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	<u>FL</u>	05 08 03	12
16	QC3	Inspect Powder Coat	<u>TM</u>	05 08 04	12
17	ST	Identify and Stock.	<u>CL</u>	05/08/04	12
18	AC	Cost / Part <u>155.27</u> <u>118.39</u>	<u>545</u>	05.08.09	12
19	DC	Close W/O <u>163.00</u> <u>131.15</u> Inspection Level 21	<u>Q9</u>	05/08/05	12

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	<i>[Signature]</i>

RELEASED
02/10/15 RF